

Work Order ID 69265

Friday, May 06, 2011 8:48:16 AM



Page 1

Item ID: D3017-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Frame Assembly

Start Date: 5/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

MNF

Date:

11-05-06

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3017

Rev B

100

Weld per dwg A/R 4130 rod Batch: *M114509* 0.00

Large Fab

Large Fab

Memo

0.00

1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017

2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)

3-Drill holes in D3017-5 Using DT8622

4-Deburr

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

6-Drill holes in back frame using DT8621

12 11-5-17 (X1)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

1 0 8611/05/17

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 11/5/17

Memo

0.00



130



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 115128.

Memo

0.00

START TIME: 1:30
OVEN TEMPERATURE: 320°
FINISH TIME: 2:00

1 BIL 11-5-17.

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

1 H 11/5/17

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location

GA

0.00

Memo

W/p
6/1/18

0.00

11/05/18 @

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/18 2/2
11-05-18
①

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Picklist Print

Friday, May 06, 2011 8:48:13 AM

Page 1

Work Order ID: 69265

Parent Item: D3017-041

Parent Item Name: Back Frame Assembly

Start Date: 5/6/2011

Required Date: 5/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19 New issue EC
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4130NT0.750W.083

Purchased

No

100

f

47.5000

2.458

2.587368



4130 RD Tube .750 x.083W

Location

Loc Qty

Loc Code

MAT033

47.5

117579

47.5

2.58

M4130NT0.750W.049

Purchased

No

100

f

33.4900

11.125

11.71053



4130 RD Tube .750 x.049W

Location

Loc Qty

Loc Code

MAT033

33.49

110740

33.49

M 117 651 x 11.7

D3017-11

Manufactured

No

100

Each

36.0000

2

2



cap

Location

Loc Qty

Loc Code

WA

34

69074

34

WA019

2

52583

2

2

D3017-7

Manufactured

No

100

Each

4.0000

3

3



Lug

Location

Loc Qty

Loc Code

WA019

4

38567

2

52915

2

69166 X 3

EL 11-5-17

EL 11-5-17

EL 11-5-17

EL 11-5-17

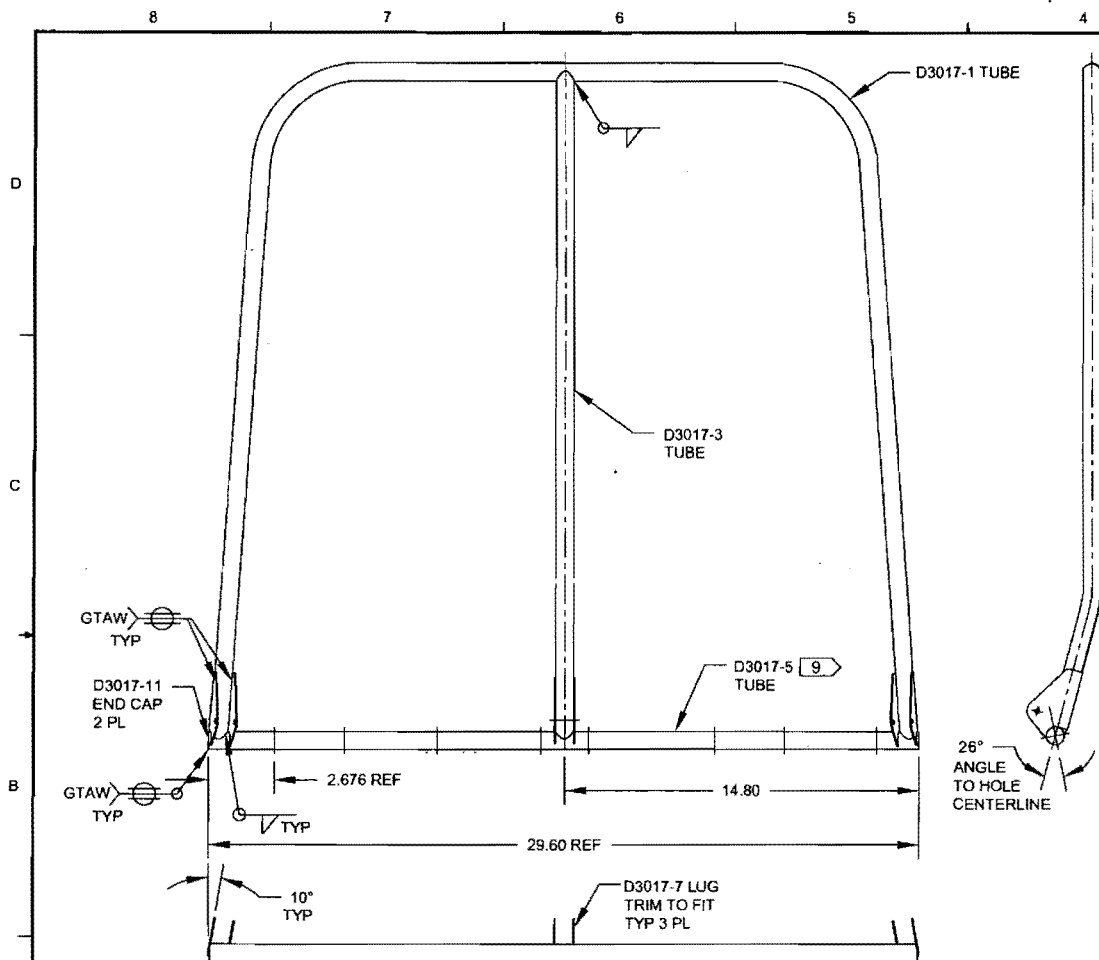
Dart Aerospace Ltd

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ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

26°
ANGLE
TO HOLE
CENTERLINE

D3017-041 BACK FRAME ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

RELEASED
2010-02-02
JPH

B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3017 SHEET 1 OF 4
TITLE SCALE
BACK FRAME ASSEMBLY NTS

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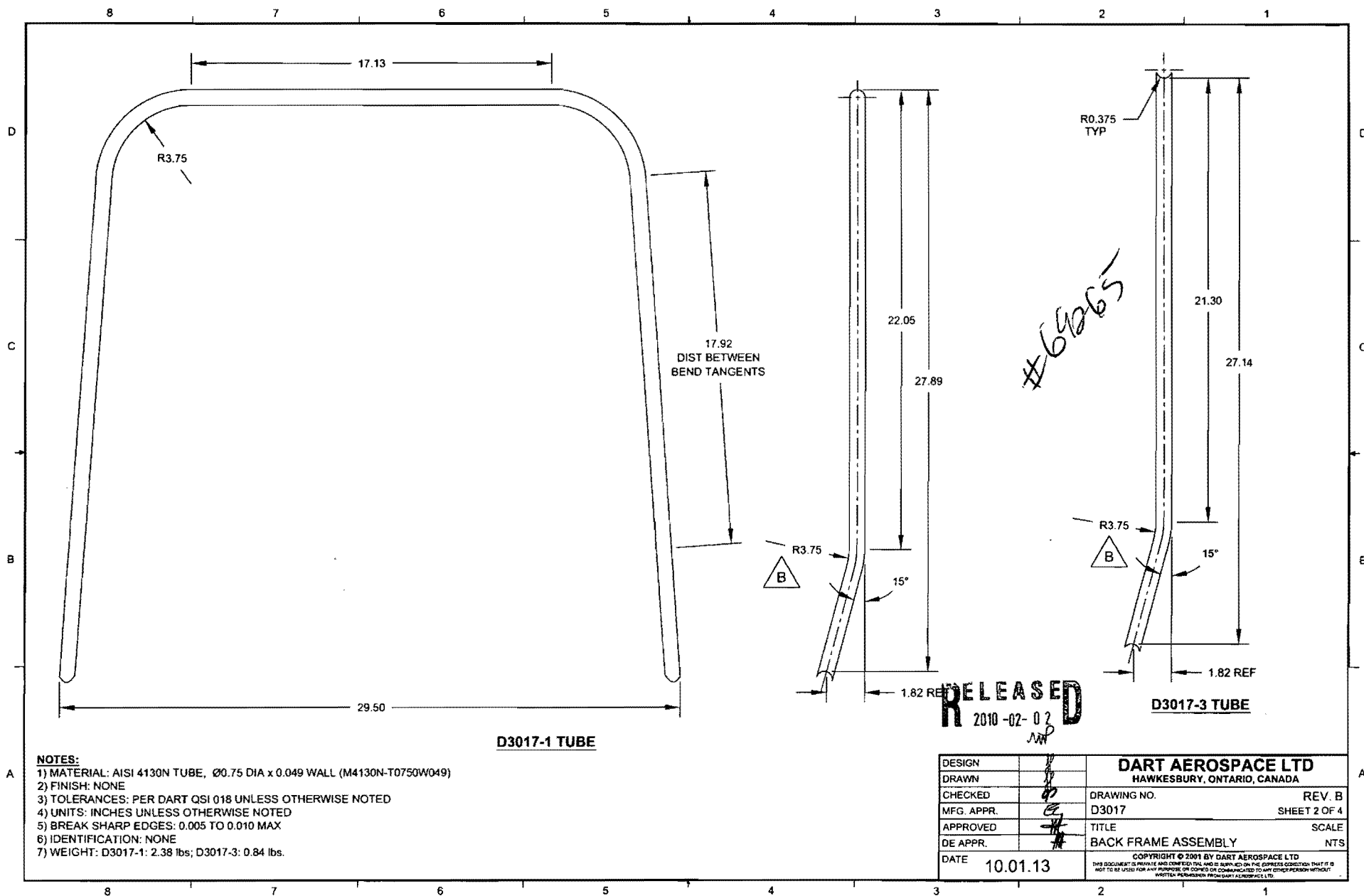
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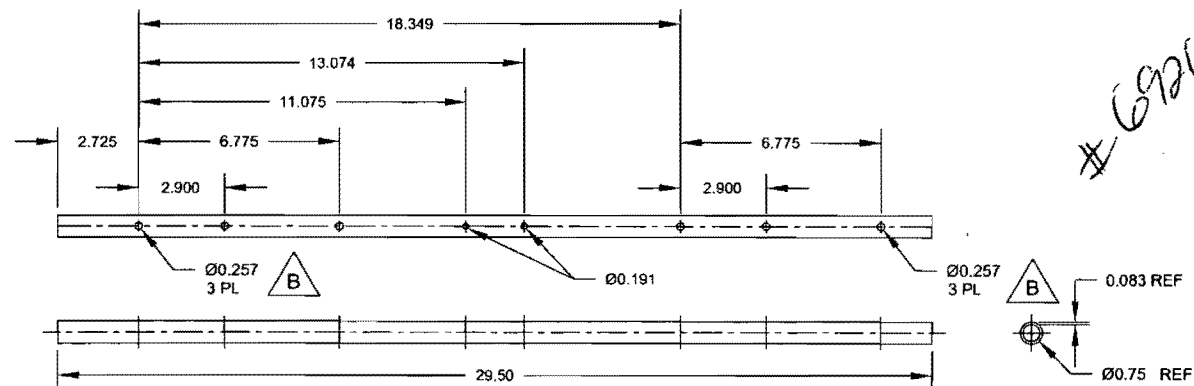
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D3017-5 TUBE

RELEASED
2010-02-02

NOTES:

- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.89 lbs

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 3 OF 4
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DE APPR.		BACK FRAME ASSEMBLY	NTS
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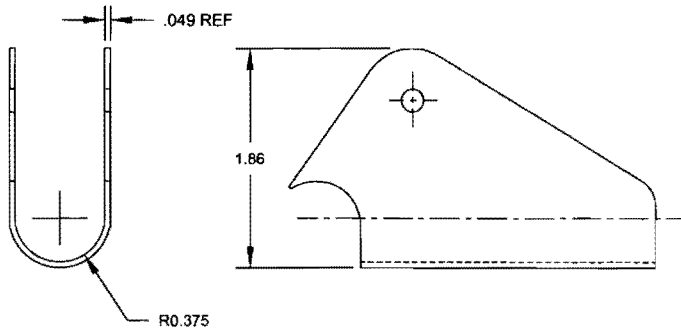
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

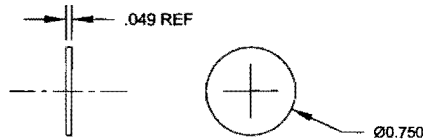
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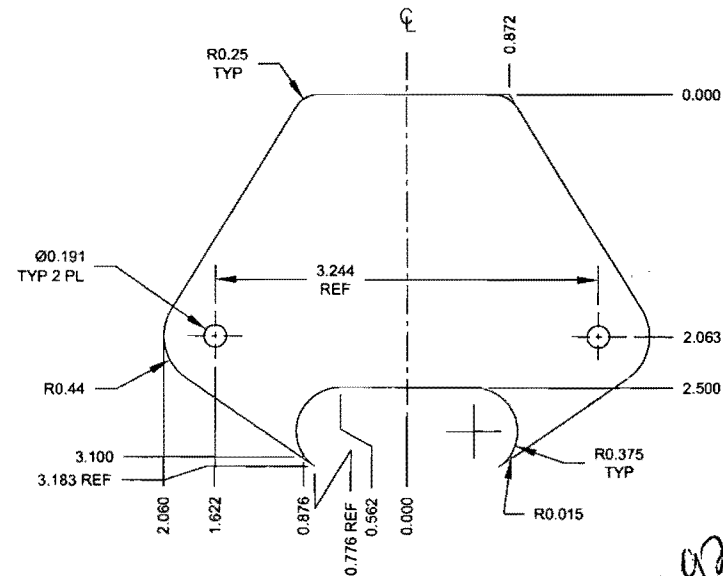
8 7 6 5 4 3 2 1



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

#69265

RELEASED
2010-02-02
MD

NOTES:

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

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8 7 6 5 4 3 2 1

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